

(C)

PLOT SCALE: .5=1

DWG. SCALE: 2

4

3

2

1

D

D

C

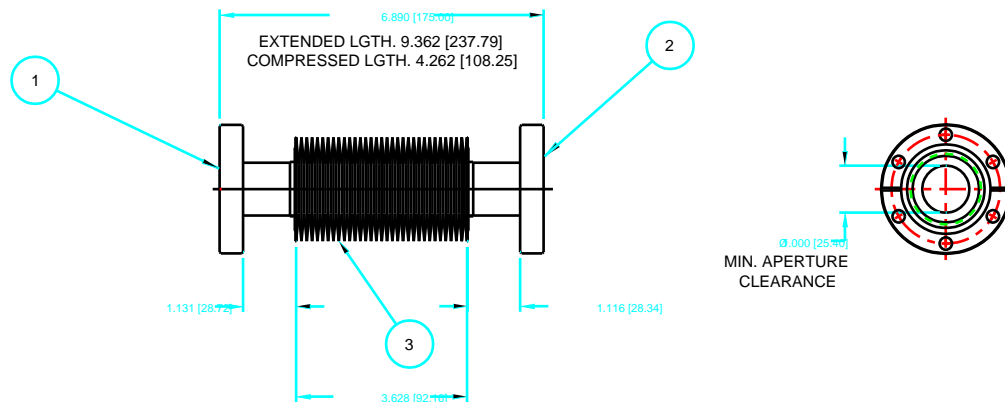
C

B

B

A

A



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL

2. ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL

3. BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS

ALCATEL SAM-110TCL
Du PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [] ARE MILLIMETERS

REF. SOURCES

2 STANDARD BELLOWS CO.
375 TUNPIKE AVE.
WINDSOR LOCKS, CONN. 06096

1 MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651



3		ST'D. BELLOWS CAT. #220 - 104 - 5 - AA	WITH EXTENDED ENDS	1
2	#100008	2 3/4" CF. ROTATABLE FLANGE		1
1	#110008	2 3/4" CF. NONROTATABLE FLANGE		1

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES				
TOLERANCES				
DECIMALS ANGLES				
.1 .03 [7.620] .25				
.XX .01 [0.25]				
.XXX .005 [0.127]				
SURFACE ROUGHNESS 125				
REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAZ				
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST 944				
POLISHING & POLISHING TO ACCORDANCE WITH LATEST ASST 944				
DO NOT SCALE DRAWING				
LOG NUMBER		THIS DRAWING IS THE PROPERTY OF		
V2750000-00		ARGONNE NATIONAL LABORATORY		
DRAWN BY		DATE	CHEF DESIGN ENGINEER	DATE
MUSCIA		7/23/97	D. SHU	7/24/97
CHECKED BY		DATE	OP LEADER	DATE
D. SHU		7/24/97	T.M. KUZAY	7/26/97
DESIGNER		DATE	PROJECT MGR	DATE
SHU/MUSCIA		7/23/97		
RESPONSIBLE ENGINEER		DATE	APPROVED/RELEASED	DATE
D. SHU		7/24/97		
MATERIAL		SEE PARTS LIST		
SCALE		HALF	SIZE	DRAWING NUMBER
SHEET 1 of 1		C		V2-750000-00

4

3

2

1